



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2521

Job Sheet 172777

Part No: D2521

Job Qty: 8 ea

Part Name: Individual Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/1/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV J IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		2/28/18	0.00	0.00	Start Up Container		See R103/06
120	Waterjet	8 pcs		2/28/18	0.00	3.01	Waterjet1	1/AS	See 18/03/06
130	CNC Vertical Machining	8 pcs		3/1/18	0.39	13.89	HAAS 1	52	18/04/10
140	QC	8 pcs		3/1/18	0.00	0.00	QC2	4-89	18/04/10
150	QC	8 pcs		3/1/18	0.00	0.00	QC8	DAE	18/04/10
160	Packaging	8 pcs		3/1/18	0.00	0.00	Packaging3	DAE	APR 11/18
170	QC21-SA	8 Ea		3/1/18	0.00	0.00	QC21	DAE	

Part Op 120 - Cut Blank as per D2521 blank file
 Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	56 sf (7 ea)	90-Start up Operation	138393 23
				138127 35

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	56	811	0

Part Specifications

Specifications could not be found.

Plex 2/21/18 4:03 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD		Work Order:	172777
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.261				
B	0.90	0.96	0.932				
C	0.27	0.330	0.305				
D	0.470	0.530	0.500				
E	21.740	21.760	21.750				
F	0.72	0.780	.748				
G	0.35	0.410	.379				
H	11.490	11.570	11.500				
I	3.41	3.47	3.410				
J	11.790	11.810	11.800				
K	9.47	9.53	9.50				
L	7.190	7.210	7.200				
M	6.910	6.970	6.934				
N	44.47	44.530	44.50				
O	6.590	6.650	6.62				
P	0.940	0.980	.970				
Q	18.97	19.03	19.00				
R	0.350	0.410	.378				
S	0.740	0.780	.765				
T	0.240	0.280	.260				
U	0.370	0.410	.392				
V	0.740	0.780	.755				
W	0.740	0.780	.765				

Measured by: DAS 52	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 9-89 18/04/09	Date: 18/04/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DQA: _____ Date: _____

QA Closed: **DAS 53** Date: **JUL 23 2018** WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: <u>172777</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS		Engineering Quality Other			
Part No. <u>09521</u>		☐ Rework ☒ Scrap ☐ Use-as-is		☐ Skid-tube Machining ☒ Thermoforming ☐ Large Fab		☐ Cross tube Small Fab ☐ Finishing Composite		☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier	
NCR No. <u>18-6913</u>				QTY Effective: <u>1</u>				MRB (QS1042) Approval DAS 9 18-04-10	
Date: <u>18/04/10</u>		Step #: <u>2/30</u>						Completed By S.C. 18/04/10	
Description Work Order Deviation				Disposition				Lead hand / Supervisor Approval Verification 18/04/10	
Depth of engraving tool not programmed properly resulting with a 1/8 hole .120 deep in part				Scrap and destroy				QC / QA Coordinator Approval DAS 9 18-04-10	
Root Cause		FAULT CATEGORY							
Environment		Pressure/Forced		Power Loss/Surge		Positioned Wrong			
Design		Bending		Folio/Program		Outside Dimensions			
Doc/Data		Centre Not Concentric		Grain		Over/Under tolerance			
Equip/Tooling		Cracks		Broken/Damage/Defect		Weld			
Handling/Pre		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled			
Material		Cuffs		Contamination		Out of Sequence			
Internal Transport		Crushing		CounterSink		Mislabeled			
Tribal Knowledge		Heat Treat		Cut Too Short		Fit/Function			
LOA		Wave/Twist in Tube		Instructions Incomplete/Unclear		Misaligned/off center			
Substation		Marks/Chatter		Drill Holes					
Past Expiry Date									
Misidentified									
No Re-verification		Temperature/Cure							
☒ Operator		☒ Set-up							
☐ Offset/Setup		☐ BOM/Route							
☐ Supplier		☐ Broken/Damage/Defect							
☐ Training		☐ Inspection Incomplete/Unqualified							
☐ Use for Testing		☐ Contamination							
☐ Poor Information		☐ CounterSink							
☐ Rushing		☐ Cut Too Short							
☐ Product Improvement		☐ Instructions Incomplete/Unclear							
☐ Process Improvement									
☐ Manufacturing Process									
☐ Past Due									
NOTES: <u>Typing error while programming engraving</u>									